

Work Order ID 86020

June-19-12 4:04:19 PM

86020

Page 1

Item ID: D3912-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eyebolt

Start Date: 19/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: 12/06/20 SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3912

B

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871AND DWG

Prog Rev: B

Dwg Rev: B

Deburr as required

SA 12/7/4

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SA 12/7/4

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:04:24 PM

Page 1

Work Order ID: 86020

Parent Item: D3912-1

Parent Item Name: Eyebolt

86020

D3912-1

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	14.3610	0.25	3.157895			
M303R2 000									**	8 12714			
303 ROUND BAR 2"													

Location

Loc Qty

Loc Code

MAT029

14.361

116656

1.427

116700

0.354

121846

12.58

304 R 2.000

115385

2.3

5.24

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

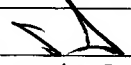
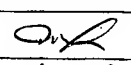
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
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86020
Description: Eyebolt		Part Number:	D3912-1
Inspection Dwg: D3912	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.130	/		5A-9	Verh
Ø0.700	+/-0.010	.699	/			
Ø0.500	+/-0.010	.498	/			
0.90	+/-0.030	.90	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.215	/			
0.75	+/-0.030	.747	/			
0.970	+/-0.010	.967	/			
1.72	+/-0.030	1.717	/			
1.20	+/-0.030	1.202	/			
0.625	+/-0.010	.627	/			
2.23	+/-0.030	2.231	/			
R0.13	+/-0.030	R.125	/		R.G	
R0.015	+/-0.010	R.015	/		R.G	
0.625	+/-0.010	.631	/			
Ø0.650	+/-0.010	.651	/			
1.100	+/-0.010	1.097	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/		R.G	
1.00	+/-0.030	1.003	/			
0.25	+/-0.030	.250	/			
0.88	+/-0.030	.884	/			
0.11	+/-0.030	.107	/			
Ø0.719	+0.010/-0.000	.723	/			

Measured by:		Audited by:		Preliminary Approval:	
Date:	12/7/14	Date:	12/10/15	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	

Dart Aerospace Ltd

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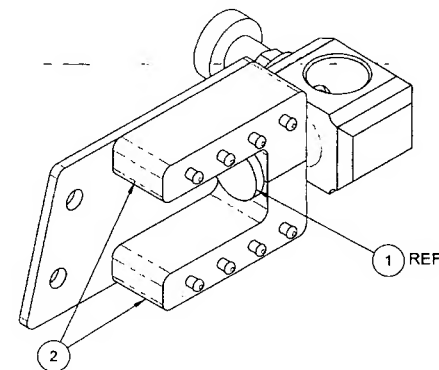
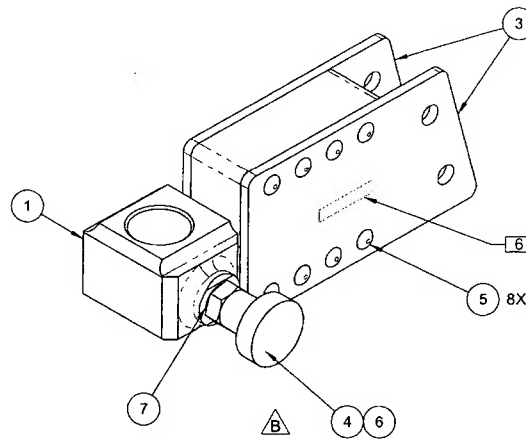
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06020 MLJ
12/06/20

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMY; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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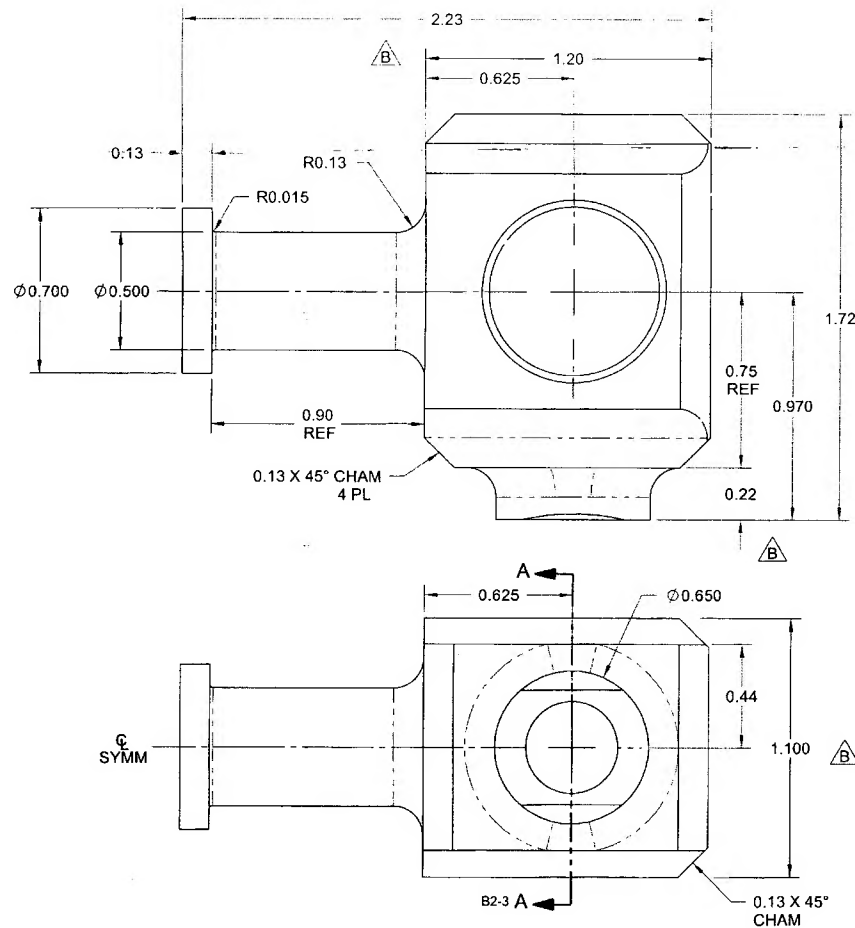
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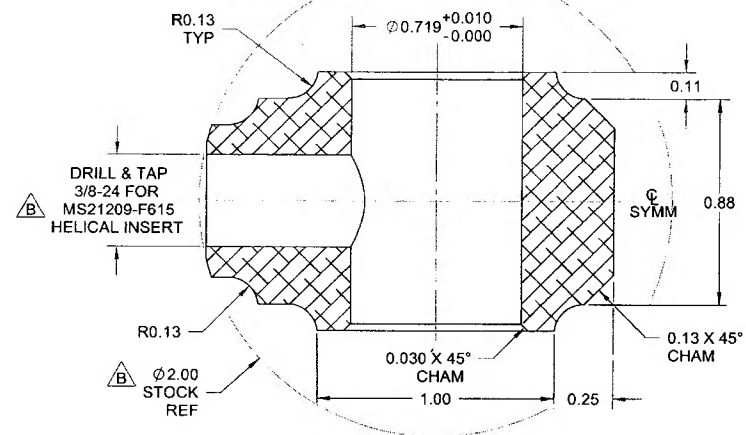
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3912	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

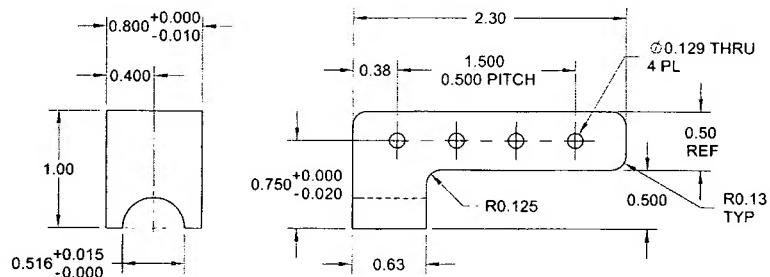
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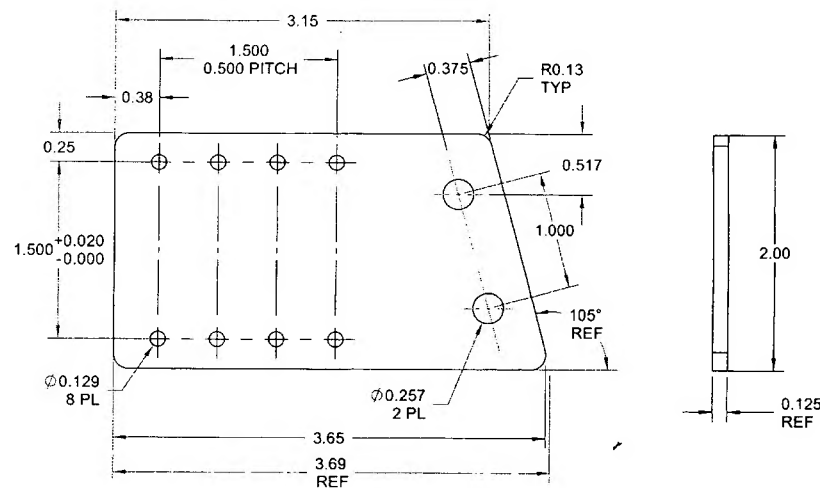
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NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs

-5: 0.24 lbs

RELEASED
2010-07-16
JMD

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	8/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8/1	DRAWING NO. D3912	REV. B
MFG. APPR.	8/1		SHEET 3 OF 3
APPROVED	8/1	TITLE	SCALE
DE APPR.	8/1	EYEBOLT RECEIVER ASSY	NTS
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